

Date: Monday, 3/17/2008 11:56:43 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R44 BEARPAW  
 Job Number : 38021A  
 Estimate Number : 12480  
 P.O. Number :  
 This Issue : 3/17/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1/ Type : MACHINED PARTS  
 Previous Run : 37315A  
 Part Number : D35291  
 Drawing Number : D3529 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 3/30/2008 Qty: 12 Um: Each  
 Written By :  
 Checked & Approved By : 3/17/08  
 Comment : Est Rev: A New Issue 06-06-28 JLM

only 12 TL.  
 NOT 24

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 1.3283 sf(s)/Unit Total: 15.9390 sf(s)

Pick:

blank: 13.5" x 13.000" x 1.00" thick (+0.030/-0.000)

Material: Black UHMW 1"(MUHMWB10)

Batch: M106161 → 9 parts

SD 08/04/30

2.0 MFG ENGINEERING MFG ENGINEERING



Comment: MFG ENGINEERING  
 Program Batch Number

SD 08/04/16

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA645 and Dwg D3529

3-Deburr

HA/SD 08/04/30

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BA/SD 08/04/30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:56:43 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 38021A

Part Number: D35291

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*OK 08/05/01*

(12)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP-38021

*JS 08/05/02*

(12)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/05/06*

Job Completion



*U 08-05-05*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|  |  |                     |         |
|--|--|---------------------|---------|
| <b>DART AEROSPACE LTD</b>                  |  | <b>Work Order:</b>  | 38021A  |
| <b>Description:</b> Bearpaw                |  | <b>Part Number:</b> | D3529-1 |
| <b>Inspection Dwg:</b> D3529 <b>Rev:</b> A |  | <b>Page 1 of 1</b>  |         |


### FIRST ARTICLE INSPECTION CHECKLIST

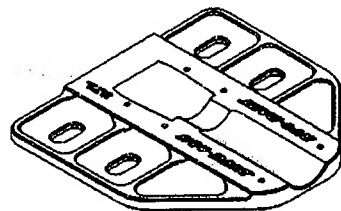
☒ First Article      ☐ Prototype

| Inspection Sheet<br>Drawing Dimension |                  | Tolerance           | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|------------------|---------------------|---------------------|--------|--------|-------------------------|----------|
| A                                     | 5.50             | +/-0.030            | 5.502               | /      |        |                         |          |
| B                                     | 0.07 x 45°       | +/-0.030 x 0.5°     | .06 x 45°           | /      |        |                         |          |
| C                                     | R0.25            | +/-0.030            | R.23                | /      |        |                         |          |
| D                                     | 0.250            | +/-0.010            | .245                | /      |        |                         |          |
| E                                     | 0.625            | +/-0.010            | .620                | /      |        |                         |          |
| F                                     | 0.950            | +/-0.010            | .951                | /      |        |                         |          |
| G                                     | 1.63             | +/-0.030            | 1.619               | /      |        |                         |          |
| H                                     | 12.14            | +/-0.030            | 12.14               | /      |        | Tape                    |          |
| I                                     | <del>10.50</del> | <del>+/-0.030</del> |                     |        |        |                         |          |
| J                                     | 5.70             | +/-0.030            | 5.687               | /      |        |                         |          |
| K                                     | 0.375            | +/-0.010            | .374                | /      |        |                         |          |
| L                                     | 0.525            | +/-0.010            | .523                | /      |        |                         |          |
| M                                     | 0.13 x 45°       | +/-0.030 x 0.5°     | .140 x 45°          | /      |        |                         |          |
| N                                     | R0.50            | +/-0.030            | R.50                | /      |        |                         |          |
| O                                     | 12.76            | +/-0.030            | 12.75               | /      |        | Tape                    |          |
| P                                     | 3.38             | +/-0.030            | 3.38                | /      |        |                         |          |
| Q                                     | 3.75             | +/-0.030            | 3.75                | /      |        |                         |          |
| R                                     | 5.187            | +/-0.010            | 5.187               | /      |        |                         |          |
| S                                     | 5.25             | +/-0.030            | 5.25                | /      |        |                         |          |
| T                                     | 7.13             | +/-0.030            | 7.125               | /      |        |                         |          |
| U                                     | Ø0.260           | +0.006/-0.001       | Ø.260               | /      |        |                         |          |
| V                                     | 0.30             | +/-0.030            | .295                | /      |        |                         |          |
| W                                     | 0.93             | +/-0.030            | .927                | /      |        |                         |          |
| X                                     | 1.30             | +/-0.030            | 1.290               | /      |        |                         |          |
| Y                                     |                  |                     |                     | /      |        |                         |          |

|                        |                        |                            |     |
|------------------------|------------------------|----------------------------|-----|
| <b>Measured by:</b> SD | <b>Audited by:</b> GML | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 08/04/01  | <b>Date:</b> 08/05/01  | <b>Date:</b>               | N/A |

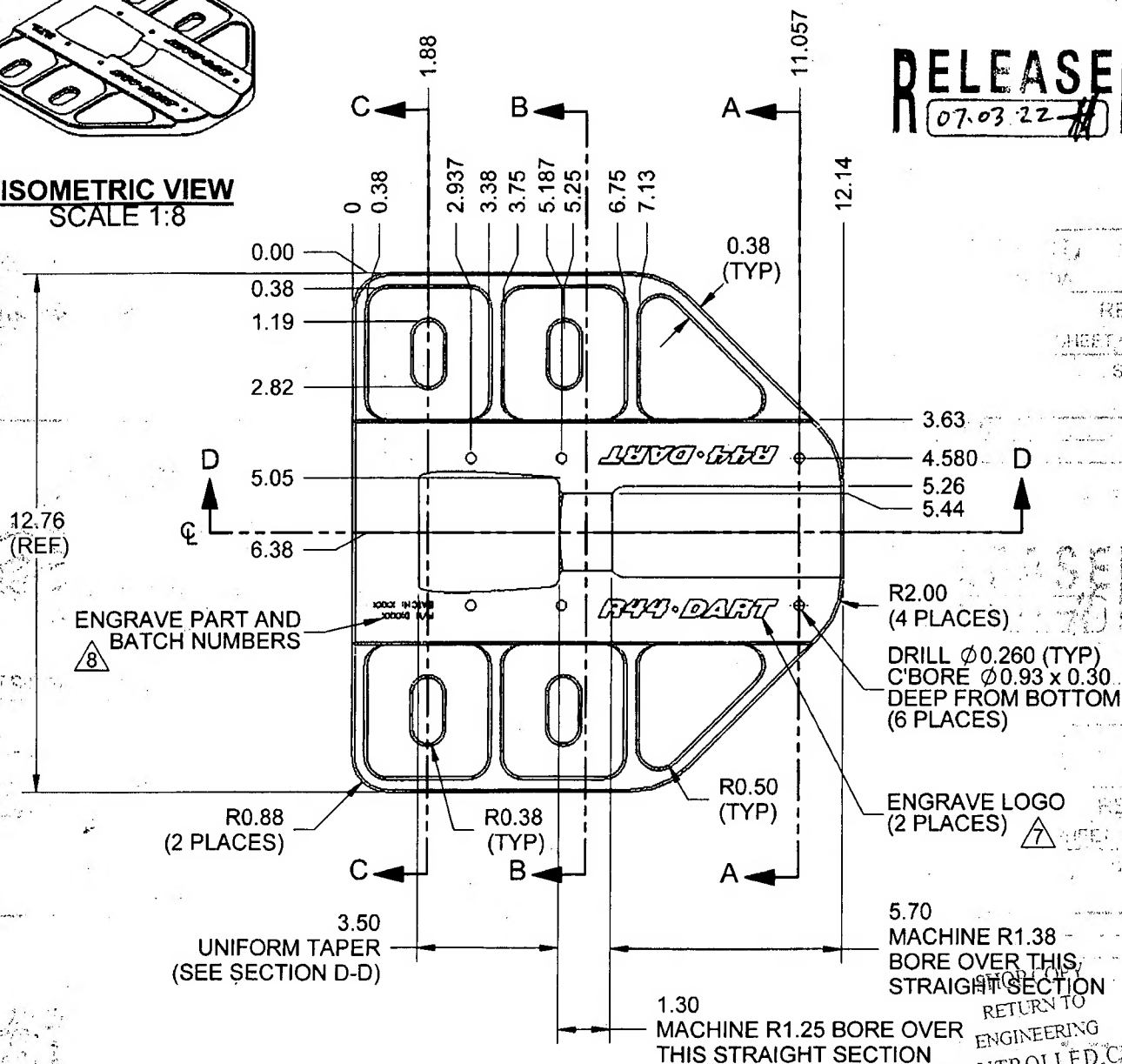
| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 07.05.01 | New Issue | KJ/JLM     |          |

|                  |   |   |                        |
|------------------|---|---|------------------------|
| DESIGN<br>CB     | DRAWN BY<br>CB  | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>B     | APPROVED<br> | DRAWING NO.<br>D3529                              | REV. A<br>SHEET 1 OF 2 |
| DATE<br>07.01.04 |   | TITLE<br>R44 BEARPAW                              | SCALE<br>1:4           |
| REV<br>A         | DATE<br>07.01.04  | DESCRIPTION<br>NEW ISSUE                          |                        |



**ISOMETRIC VIEW**  
**SCALE 1:8**

RELEASED  
07.03.22



**D3529-1 R44 BEARPAW**

**NOTES:**

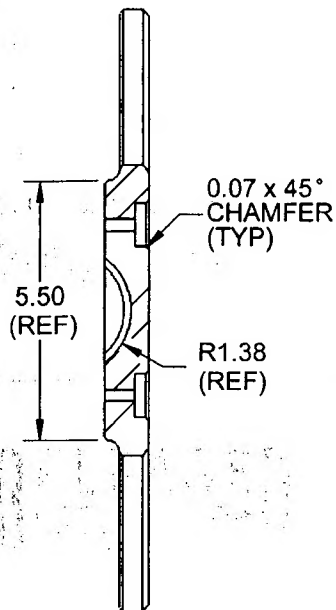
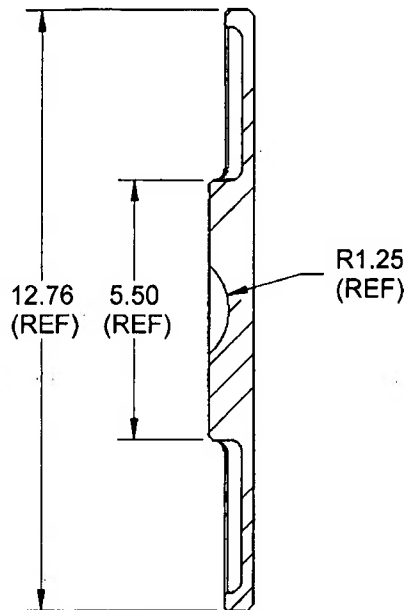
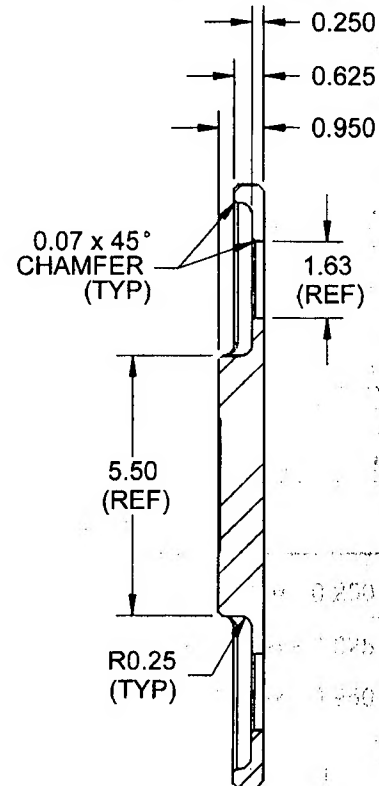
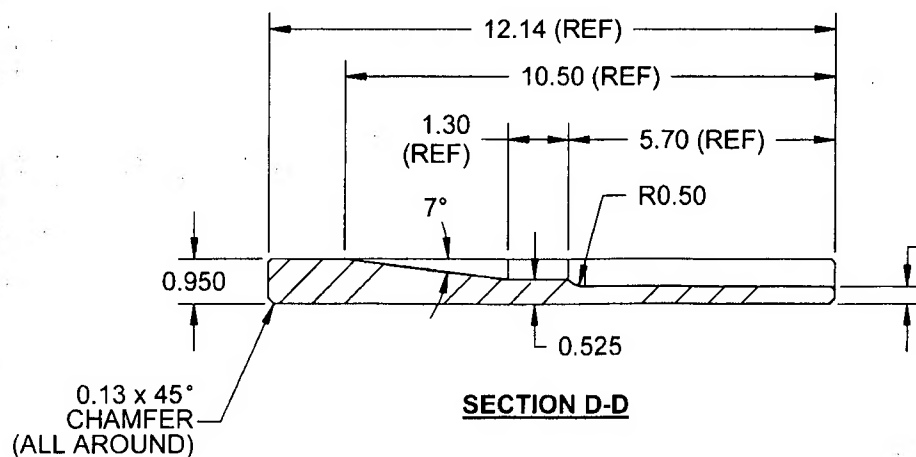
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE  
2) FINISH: NONE  
3) PART IS SYMMETRIC ABOUT C  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE IN INCHES  
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX  
7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN  
8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

**COPYRIGHT © 2007 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

|                  |                |   |                        |
|------------------|----------------|---|------------------------|
| DESIGN<br>CB     | DRAWN BY<br>CB | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>B     | APPROVED<br>M  | DRAWING NO.<br>D3529                              | REV. A<br>SHEET 2 OF 2 |
| DATE<br>07.01.04 |                | TITLE<br>R44 BEARPAW                              | SCALE<br>1:4           |

**RELEASED**  
07.03.22**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38021 A

COPYRIGHT © 2007 BY DART AEROSPACE LTD

DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

